

Work Order ID 100608

April-24-13 11:45:44 AM

\*100608\*

Page 1

Item ID: D4682-9

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Wearplate Shim

Start Date: 4/24/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals:

Process Plan: MCS

Date: 13-04-24

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4682

A

110

0.00

\*110\*

Waterjet

FLOW CNC Waterjet

Memo

0.00

1-Cut as per dwg D4682

prog rev: A

dwg rev: A

2-Deburr if required

10

DAS  
05  
13.04.25

120

QC2- Inspect parts off machine FAI/FAIB

0.00

\*120\*

QC

Quality Control

Memo

0.00

10

DAS  
05  
13.04.25

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Page 2

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Start Date: 4/24/13 Start Qty: 10.00

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Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

\*NR2\*

| Sequence ID/<br>Work Center ID         | Operation<br>Description                                  | Set Up/<br>Run Hours    | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--|---|-------------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130<br>*130*<br>QC<br>Quality Control  | QC8- Inspect parts - second check<br><br>Memo             | 0.00<br>0.00<br>13.4.25 |         |        |              | 10            |               |                  |                |
| 140<br>*140*<br>Small Fab<br>Small Fab | Memo<br>Form as per dwg D4682                             | 0.00<br>0.00            |         |        |              | 10            |               |                  | SB 13/04/25    |
| 150<br>*150*<br>QC<br>Quality Control  | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>0.00<br>13.4.26 |         |        |              | 10            |               |                  |                |

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Wearplate Shim

Stop \*NS2\*

Start Date: 4/24/13 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 5/01/13 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                             | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 210                            | Identify as per dwg & Stock Location: <i>W/P 001</i> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*210*</b>                   |  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo   | 0.00                 |         |        |              | <i>10</i>     | <i>EL</i>     | <i>13-5-28</i>   |                |
| Packaging                      |  |                      |         |        |              |               |               |                  |                |
| 220                            | QC21- Final Inspection - Work Order Release          | 0.00                 |         |        |              |               |               |                  |                |
| <b>*220*</b>                   |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

*13/5/29*

*MLC 13-05-29*

# Picklist Print

April-24-13 11:45:47 AM

Page 1

Work Order ID: 100608

\*100608\*

Parent Item: D4682-9

\*D4682-9\*

Parent Item Name: Wearplate Shim

Start Date: 4/24/13

Required Date: 5/01/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 13.04.24 NEW ISSUE DD VEREJLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

M304S18GA

Purchased

No

110

sf

287.6699

0.1567

1.649474

\*\*

W 13.04.25

\*M304S18GA\*

304/316 .050 Sheet

## Location

## Loc Qty

## Loc Code

MAT019

193.3

117188

5

117766

5

120604

5

122325

3

123155

3

124572

172.3

MAT020

94.369894

120243

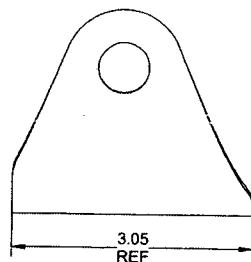
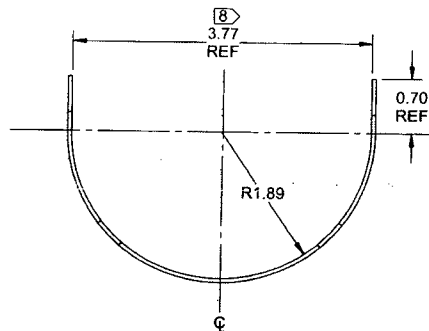
2

121626

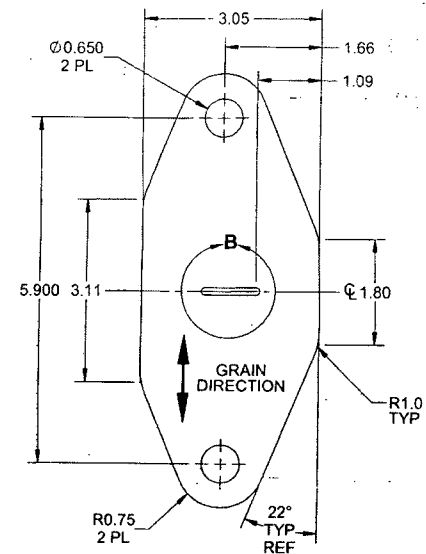
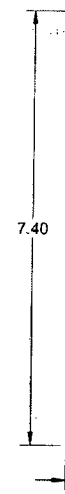
1.529894

124029

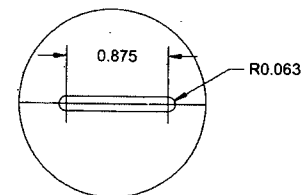
90.84



**D4682-9 WEARPLATE SHIM**  
(MAKE FROM D4682-9F)



**D4682-9F WEARPLATE SHIM**  
(FLAT PATTERN)



**DETAIL B**  
SCALE 2X

**RELEASED**  
2013-03-25

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK (REF DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.24 lbs
- 8) IT IS ACCEPTABLE TO OVERBEND D4682-9 UP TO 2 DEG OR UNDERBEND UP TO 5 DEG

|            |          |   |              |
|------------|----------|---|--------------|
| DESIGN     | AP       | <b>DART AEROSPACE USA, INC.</b>   |              |
| DRAWN      | AP       | KENT, WA  |              |
| CHECKED    | AS       | DRAWING NO.   | REV. A       |
| MFG. APPR. |          | D4682   | SHEET 7 OF 7 |
| APPROVED   |          | TITLE   | SCALE        |
| DE APPR.   |          | WEARPLATE ASSY  | NTS          |
| DATE       | 13.02.13 | COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. |              |

